

# Work Order ID 86639

Friday, July 06, 2012 9:10:19 AM

**\*86639\***

Page 1

Item ID: D3209-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bracket Assembly

Start Date: 7/6/2012 Start Qty: 4.00 **\*4\***

Cust Item ID:

Required Date: 7/11/2012 Req'd Qty: 4.00 **\*4\***

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: 12-07-06 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3209	Rev A								
100		0.00							
<b>*100*</b>	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000)								
110		0.00							
<b>*110*</b>	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine D3209-1 as per Folio FA345 and Dwg D3209 Identify as D3209-1								
	Deburr and Tumble								
120		0.00							
<b>*120*</b>	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

*Friday 12/07/08*

*B.A 12/07/06*

*10 0*

*12/07/08*

*10 0*

*12/07/08*

*10 0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Bracket Assembly

Stop **\*NS2\***

Start Date: 7/6/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 7/11/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00

**\*130\***

QC

Memo

0.00

Quality Control

S/R 12-07-09 (X10)

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

10 7/6 12-7-10

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

**\*150\***

Powdercoat

Memo

0.00

Powder Coating

Note: Cover the hole for D3209-1 before powder coat. START TIME: 11-30 OVEN TEMPERATURE:

FINISH TIME: 12-00

10X 12/07/10

M121279

3200F

12-00

W/O:		WORK ORDER CHANGES					
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**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Bracket Assembly

Stop

**\*NS2\***

Start Date: 7/6/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 7/11/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

161

Memo  
press fit bushing as per dwg

0.00

**\*161\***

Small Fab

0.00

Small Fab

170

QC5- Inspect part completeness to step on W/O

0.00

**\*170\***

QC

Memo

0.00

Quality Control

10 0 127-10

10 12/07/17

(10)

DAS 16 9-83 12/07/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 7/6/2012 Start Qty: 4.00 **\*4\***

Cust Item ID:

Required Date: 7/11/2012 Req'd Qty: 4.00 **\*4\***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start **\*NR1\***

QC: Date:

SPC (Y/N): Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

180

Identify as per dwg & Stock Location WA

0.00

**\*180\***

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

10212/8/188012/7/19MF  
12-09-18

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Friday, July 06, 2012 9:10:18 AM

Page 1

Work Order ID: 86639  
Parent Item: D3209-041  
Parent Item Name: Bracket Assembly

Start Date: 7/6/2012 Required Date: 7/11/2012  
Start Qty: 4.00 Required Qty: 4.00

Comments: IPP A04.06.09New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3209-3 Bushing		Manufactured	No			100	Each	7.0000	1	4			
--------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location Loc Qty Loc Code

ST033 7  
40930 7

M6061T6B1.500X01.250 6061-T6 Bar 1.50 x 1.25		Purchased	No			170	f	19.3170	0.175	0.7368421			
---	--	-----------	----	--	--	-----	---	---------	-------	-----------	--	--	--

Location Loc Qty Loc Code

MAT003 7.317  
118071 0.112  
119513 0.945  
121660 6.26  
MAT004 12  
122081 12

(1.5 x 1.5) 120540

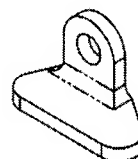
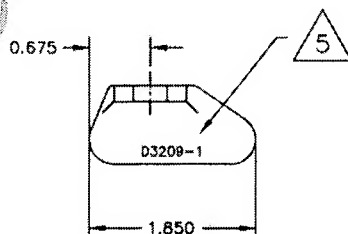
1.675<sup>st</sup>

\* mat not pulled  
from system

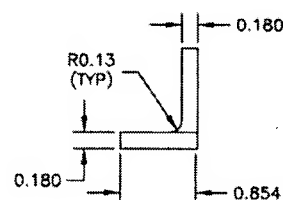
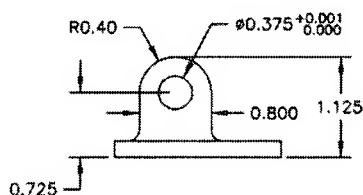


DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED TF	APPROVED TF	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED  
04.04.05

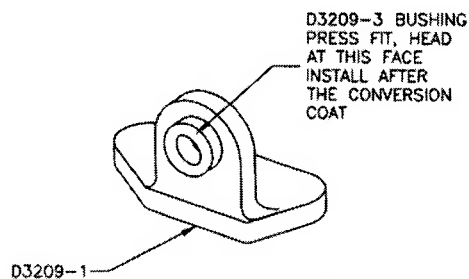
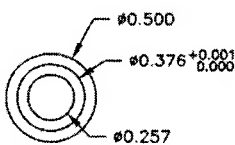
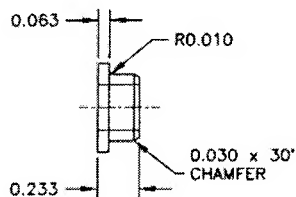


# 86639



2

**D3209-1 BRACKET**



4

**D3209-041 ASSEMBLY**

3

**D3209-3 BUSHING  
SCALE 1:2**

**D3209-1 BRACKET: D3209-3 BUSHING**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)  
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries